

Work Order ID 150657

Monday, August 29, 2016 2:55:46 PM

150657

Page 1

Item ID: D2680-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Nut Plate
Start Date: 8/19/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 8/29/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: DAS Date: AUG 30 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2680	Rev B1
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100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D2680 Dwg Rev: B1 Prog Rev: B1 2-
Deburr if necessary

0.00

0.06

12PR 16/09/09

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.02

12PR 16/09/09

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.04

(12)DAS
16
9-8916/09/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____



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OTHER : ☐					

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Page 3

Setup Start *NS1*

Stop *NS2*

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

160 QC3- Inspect Part Finish

Memo

QC

Quality Control

170	0.00
-----	------

Small Fab

Small Fab

Memo

Small Fab

Install Nut Plate as per Dwg D2680

180	QC5- Inspect part completeness to step on W/O	0.00
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Memo

QC

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order ID 150657

Monday, August 29, 2016 2:55:46 PM

150657

Page 4

Item ID: D2680-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nut Plate

Start Date: 8/19/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							DAS 6 9-89
190						12		SEP 22 2016	
Packaging	Memo	0.02							
Packaging	LOCATION :LG001								
200	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89
200								SEP 22 2016	
QC	Memo	0.20							
Quality Control									DAS 21 9-89

SEP 22 2016

DQA: _____ Date: _____



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OTHER : _____					

Picklist Print

Monday, August 29, 2016 2:55:45 PM

Page 1

Work Order ID: 150657

150657

Parent Item: D2680-041

D2680-041

Parent Item Name: Nut Plate

Start Date: 8/19/2016

Required Date: 8/29/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: D04.10.01Added Steps 2-4, 7-8KJ/JLM
IPP Rev:E Now on WaterJet 06-10-12 JLM
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA		Purchased		No		170	sf	86.9000	0.0131	0.165474			
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M1010S16GA

1010/1025 sheet 16GA

★★

PR 16/09/09

Location

Loc Qty

Loc Code

MAT019

86.9

124428

86.9

0.2

MS20426AD3-3

Purchased

No

170

Each

6,616.000

2

24

MS20426AD3-3

RIVET

★★

16/09/21 DAS 36 9-89

Location

Loc Qty

Loc Code

fg108

400

M135354

400

GA

80

M131624

80

ST312

6136

M135274

6136

24

MS21069L4

Purchased

No

110

Each

17.0000

1

12

MS21069L4

Nut Plate

★★

16/09/21 DAS 36 9-89

Location

Loc Qty

Loc Code

ST299

17

120498

2

m128636

11

m134167

4

4

M135600 8x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

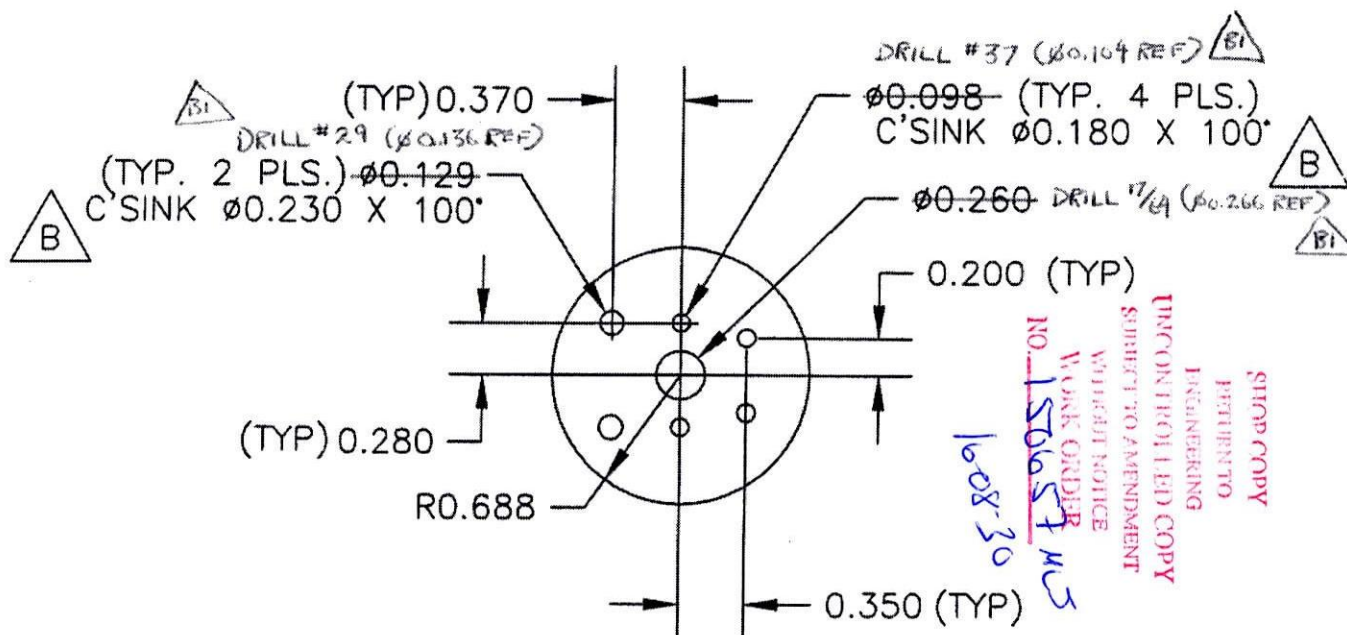
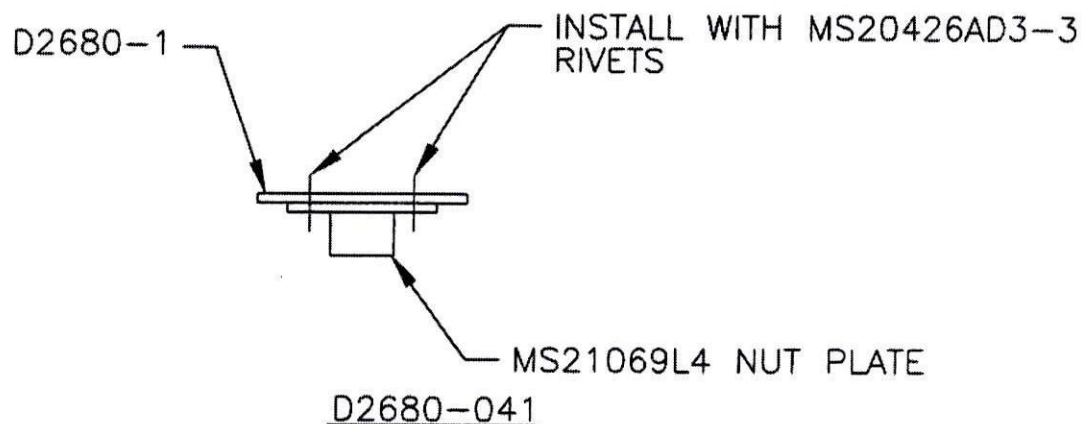
Work Order update only ☐

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DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE		SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	CP # 04.11.04	CHANGE HOLES & FINISH	

RELEASED
98.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B1 POWDER COAT WHITE (4.35.2) PER DART QSI 005 4.3
D2680-1